

Date: Monday, 5/15/2006 11:12:16 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
 Job Number : 27118
 Estimate Number : 10939
 P.O. Number : N/A Part Number : D29382
 This Issue : 5/15/2006 S.O. No. : N/A Drawing Number : D2938 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : 5/15/2006 Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 26370 Material : N/A
 Written By : See Comment Below Due Date : 5/30/2006 Qty: 8 Um: Each
 Checked & Approved By : 06.05.15
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: B24891

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

SL/SP 06.06.09

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SL/SP 06.06.09

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SL/SP 06.06.09

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SL/SP 06.06.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 06/07/28

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:12:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 27118

Part Number: D29382

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

SAD 06/07/25

540
728

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/25
PL

8
72

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AR 06/07/27

8

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 416

AR 06/07/27

8

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DD 06/07/28

8

Job Completion



HA 06.07.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27118
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.116	.115	.117	.117		
B	0.100	0.140		.116	.119	.119	.119		
C	0.100	0.140		.118	.117	.117	.118		
D	0.210	0.230		.224	.228	.225	.227		
E	1.245	1.255		1.256	1.250	1.250	1.256		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.125	.125	.124		
O	0.540	0.560		.549	.545	.549	.545		
P	0.490	0.510		.494	.492	.499	.497		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.742		
S	0.240	0.270		.254	.254	.254	.255		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.250	1.270		1.262	1.263	1.264	1.263		
Y	1.565	1.585		1.574	1.576	1.577	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06.06.08

Audited by:	91
Date:	06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

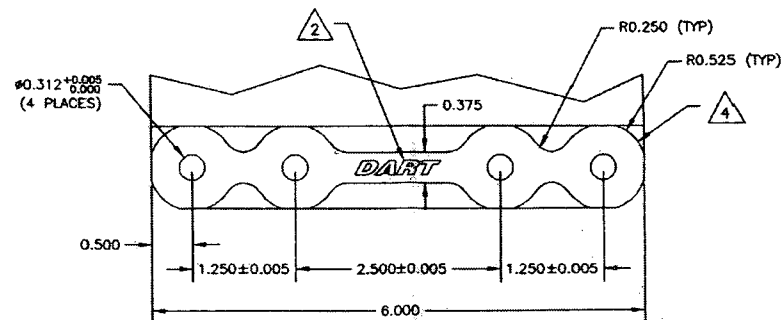
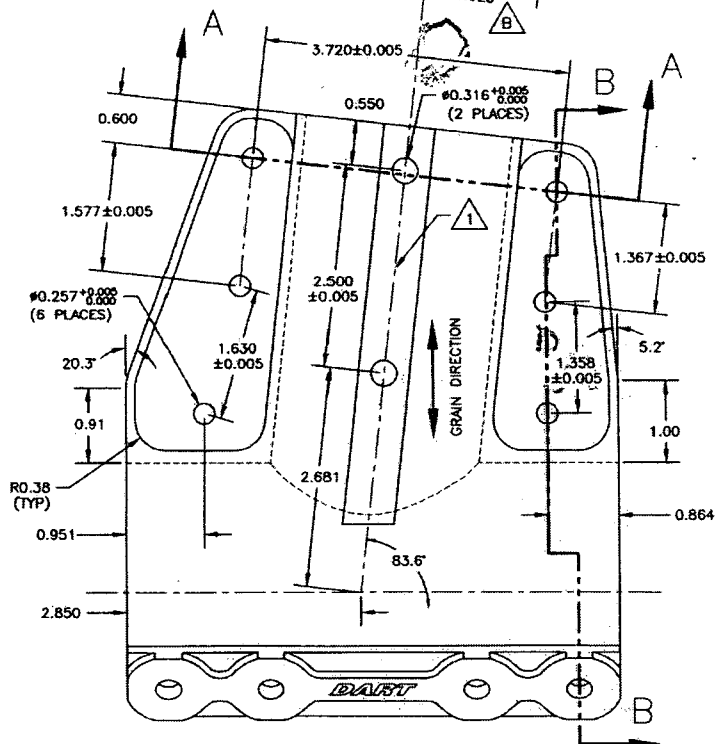
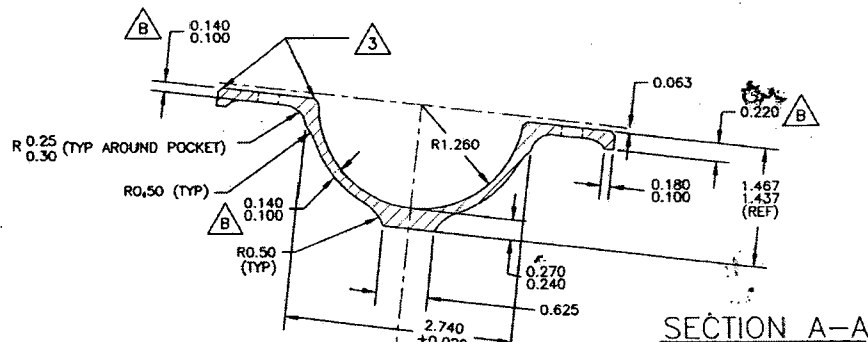
DART AEROSPACE LTD	Work Order:	27118
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.117	.116	.117		
B	0.100	0.140		.121	.117	.118	.115		
C	0.100	0.140		.117	.115	.115	.115		
D	0.210	0.230		.227	.228	.228	.228		
E	1.245	1.255		1.256	1.250	1.256	1.258		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.125	.125	.124	.125		
O	0.540	0.560		.548	.548	.548	.540		
P	0.490	0.510		.445	.457	.458	.457		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.742		
S	0.240	0.270		.255	.255	.254	.254		
T	0.100	0.180		.142	.142	.142	.142		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.250	1.270		1.264	1.259	1.265	1.265		
Y	1.565	1.585		1.573	1.573	1.578	1.574		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

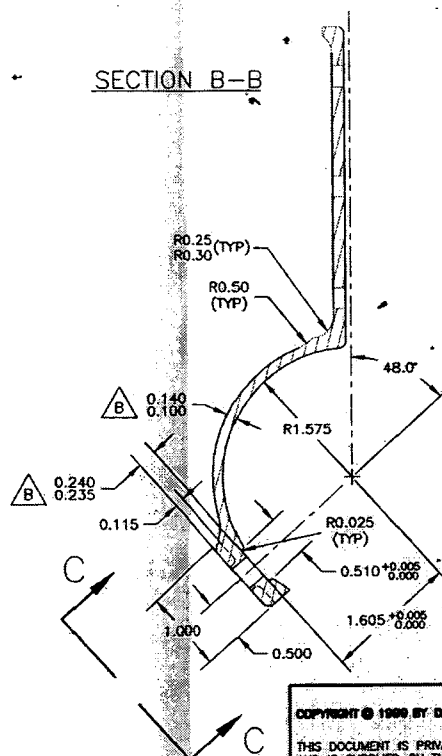
Measured by: SA	Audited by: [Signature]
Date: 06-06-09	Date: 06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#



VIEW C-C

SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4:1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4:3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED
00-05-31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	<i>[Signature]</i>	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	<i>[Signature]</i>	DRAWING NO. D2938
DATE	00.05.29	TITLE SADDLE OUTSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3

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NO. 27118

